



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

004460

646.4002
Job Sheet 180813



Part No: 646.4002

Job Qty: 1 ea

Part Name: AS350 Wiper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/27/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.07 DWG REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/27/18	7/27/18	0.00	0.00	Start Up Stores/Pkg-1		8102 L E 1111
110	Packaging	1 pcs	7/27/18	7/27/18	0.00	0.00	Packaging1-1		JUL 17 2018
120	QC	1 pcs	7/27/18	7/27/18	0.00	0.00	QC4		JRB
130	Packaging	1 pcs	7/27/18	7/27/18	0.00	0.00	Packaging3-1		JRB
135	DC	1 pcs	7/27/18	7/27/18	0.00	0.00	DC		JRB
140	QC21-FG	1 Ea	7/27/18	7/27/18	0.00	0.00	QC21		JUL 30 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4002 Location : FG102
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5065340
646.3410	LH Wiper Deflector	1 Ea (1 ea)	90-Start up Operation	5081424
646.3411	RH Wiper Deflector	1 Ea (1 ea)	90-Start up Operation	5084703
646.3814	Wiper Bracket	2 Ea (2 ea)	90-Start up Operation	5070535
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5078107
MS24694-S53	Screw	2 Ea (2 ea)	90-Start up Operation	5113359
MS27039-1-18	Screw	2 Ea (2 ea)	90-Start up Operation	5124326
MS27039-1-19	Screw	2 Ea (2 ea)	90-Start up Operation	5065263
NAS1149F0332P	Washer	16 Ea (16 ea)	90-Start up Operation	5071415

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	24	0
	646.3410	1	9	0
	646.3411	1	9	0
	646.3814	2	14	0
	MS21042L3	6	1,869	0
	MS24694-S53	2	201	0
	MS27039-1-18	2	1,260	0
	MS27039-1-19	2	386	0
	NAS1149F0332P	16	1,357	0



Container No: S092736

Part: 646.4002

Job No: 180813

Serial No/Batch: S092736

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/17/18

Part Specifications

Specifications could not be found.

Plex 7/17/18 7:26 AM dart.lacelle.linda

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24716.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 A1 CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

REFERENCE ONLY

UNINCORPORATED ECN(S)

05304

REFERENCE ONLY

	5		5	78	601.3875	SCREW				
	1		1	77	646.9410	SHIM				
		4	4	76	601.2764	WASHER	NAS1118FNB32P			
		2	2	75	601.2973	LOCKNUT	MS21042-08			
		2	2	74	601.2988	SCREW	MS27039-0813			
		2	2	73	601.2943	LOCKNUT	MS21042-0			
		2	2	72	601.3128	NUT	AN316CAR			
		2	2	71	601.3209	LOCKNUT	MS21042-4			
		4	4	70	601.2638	WASHER	NAS1118FNB32P			
		2	2	69	601.2669	BOLT	AN4C7A			
		2	2	68	601.3119	CLEVIS	AN665-34R			
		2	2	67	601.3121	EYE BOLT	AN66-5A			
		2	2	66	650.9201	EYE BRACKET ASSY				
		REF	REF	65	647.5701	GPS MOUNT KIT				
			2	64	601.3151	WASHER	NAS1118FNB32P			
			2	63	601.2911	SCREW	MS24694553			
		24	24	62	601.2637	SCREW	MS27039-1-16			
	2	2	2	61	601.2763	BOLT	AN3-12A			
			1	60	646.3913	SHIM				
			4	59	646.3912	SHIM				
			1	58	646.3911	SHIM				
			4	57	646.3910	SHIM				
			5	56	600.1013	PRIMER				
		8 FT	8 FT	55	600.0129	VHB TAPE				
		1	1	54	600.1012	SEALANT	PR-103 CLASS B			
			1	53	600.0991	MAGNOBOND 6398 PART B				
			1	52	600.0990	MAGNOBOND 6398 PART A				
	6	10	10	51	601.2826	BOLT	AN3-11A			
			2	50	646.3814	WIPER BRACKET				
			2	49	601.2910	SCREW	MS27039-1-18			
	2		2	48	601.1365	SCREW	MS27039-1-10			
	2		2	47	646.3719	DOUBLER				
		2	2	46	646.3718	CUSTOM WASHER				
		1		45	646.3717	DOUBLER				
		22	22	44	601.1948	SCREW	MS27039-1-19			
		2	2	43	601.1952	SCREW	MS27039-1-20			
			4	42	601.1956	SCREW	MS27039-1-21			
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 0219, 0220, 02718 & 02745	03/08/2010	P. BRAVO
B	INCORPORATED ECN 0204, 0207, & 0471	11/04/2014	P. BRAVO
C	INCORPORATED ECN 0308	06/09/2015	P. BRAVO

		2	2	41	601.2829	SCREW	MS24694554			
		2	2	40	601.2831	RIVET	MS20426ADS-7			
		1	1	39	646.3716	GAUGE BRACKET				
		6	6	38	601.1953	SCREW	MS27039-1-12			
	2	2	2	37	646.3715	STRUT DOUBLER				
12	36	2	2	36	601.2824	BOLT	AN3-5A			
6	18		18	35	601.2277	RIVET	CCW24483-00			
3	3		3	34	600.0795	NUTPLATE	MS21047-3			
1	1		1	33	601.2565	RIVET	MS20470ADS-7			
4	4		4	32	646.3813	STRUT BRACKET				
2	2		2	31	601.2822	BOLT	AN3-3A			
8	8		8	30	646.3812	GUSSET BRACKET				
1	1		1	29	601.2564	RIVET	MS20470ADS-6			
	1	1	1	28	646.3714	GUSSET				
	1	1	1	27	646.3610	FILLER				
	3	3	3	26	601.2830	SCREW	MS24694555			
	2	2	2	25	601.2825	BOLT	AN3-6A			
	1	1	1	24	646.3811	RADIUS BLOCK				
	1	1	1	23	646.3712	CLIP				
	1	1	1	22	646.3711	CLIP				
8	8		8	21	601.2832	RIVET	MS20470ADS-5			
14	14		14	20	601.2020	RIVET	CR3213-5-3			
4	6	4	6	10	19	601.2823	BOLT	AN3-4A		
	1	1	1	18	601.2827	BOLT	AN3-13A			
	5	5	5	17	601.2912	SCREW	MS24694551			
1	1		1	16	646.3713	GUSSET				
1	1		1	15	646.3210	SUPPORT				
	1	1	1	14	646.3710	DOUBLER				
	1	1	1	13	646.3110	CHANNEL				
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS21042-3	
16	32	18	120	16	144	11	601.1607	WASHER	NAS1118FNB32P	
				1	10	646.3410	LH WIPER DEFLECTOR			
				1	9	646.3411	RH WIPER DEFLECTOR			
				2	8	647.7703	STRUT ASSY			
				2	7	647.0112	STRUT BRACKET			
	1	1	1	6	646.3511	STRUT				
	1	1	1	5	646.3510	STRUT				
2	2		2	4	646.3810	BRACKET				
			1	3	646.2910	DEFLECTOR				
	1	1	1	2	646.3001	LOWER CUTTER ASSY				
			1	1	646.3301	UPPER CUTTER ASSY				
X					646.4006	LOWER CUTTER FIXED PROVISIONS KIT				
	X				646.4005	LOWER CUTTER REMOVABLE PROVISIONS KIT				
		X			646.4004	FIXED PROVISIONS KIT				
			X		646.4003	CABLE CUTTERS KIT WITHOUT FIBER PROVISIONS				
				X	646.4002	AS350 WIPER DEFLECTOR KIT				
				X	646.4001	AS350 CABLE CUTTERS KIT				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY	NEXT ASSY (S)	ORIGINAL DATE 08-27-08	DESIGNED BY P. BRAVO	CHECKED BY P. BRAVO	DATE 08-27-08
		APPROVED BY P. BRAVO		DATE 08-27-08	
		CONTRACT NO.			
		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 ANGLES ±.5°			
		SIZE B			
		SCALE NONE			
		SHEET 1 OF 5			

DART 3030 ENTERPRISE CT., SUITE A
APICAL INDUSTRIES INC. (760)-724-5300

AS350 CABLE CUTTERS KIT

SET: 646.4000 DWG. NO: 07M26
SCALE: NONE SHEET: 1 OF 5

Kim Johnston

From: Sonia Quirion
Sent: Tuesday, July 17, 2018 1:20 PM
To: Kim Johnston
Subject: I/b

646.4002 s092736 x1
d205-641-011 s092772 x4